

Date: Thursday, 16/10/2008 10:44:23 AM  
User: Julie Dawson

## **Process Sheet**

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: BASKET BASE ASSEMBLY (350)		
<b>Job Number</b>	: 42628C			<b>Part Number</b>	: D2221		
<b>Estimate Number</b>	: 10189			<b>Drawing Number</b>	: D2221 REVG		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 16/10/2008	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: G		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / /	<b>Type</b>	: LARGE FAB ASSY	<b>Due Date</b>	: 05/11/2008	<b>Qty:</b>	1
<b>Previous Run</b>	: 42625C			<b>Um:</b>	Each		
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	: <u>JUL 08 .10.10</u>						
<b>Comment</b>	Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC						

## **Additional Product**

Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop
		
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	4 D3166-1 RIB <u>B42716</u>	<u>SAD</u> <u>08/11/05</u>
2.0	D22323	Basket Hinge
		
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	✓ 2 D2232-3 Hinge bracket <u>B39334</u>	<u>AS</u> <u>08/11/12</u>
3.0	D2325	Support Gusset (350 Basket)
		
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	✗ 4 D2325 Support Gusset <u>B38741</u>	<u>AS</u> <u>08/11/11</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 42628C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch  
2 D2327-3 Bushing B39560

*SAD 08/11/11*

5.0 D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch  
2 D2581 Mounting Bracket B40895

*SAD 08/11/11*

6.0 D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch  
2 D3442-1 Shim B40392

*SAD 08/11/12*

7.0 M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch  
39.69 sf M304EX0.75-16F Expanded Metal M109383

*SAD 08-11-13 6*

8.0 M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.065 wall 304/316 SStubing

Batch: M109731

*SAD*

*08/10/10*

*①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 42628C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235 ✓

2-Drill hole in D2221-3 as per Dwg D2221 ✓

3-Deburr ✓

4-Remove all markings on material before welding ✓

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required ✓

SM 08/11/10

10.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11.0 QC6

DIMENSIONAL CHECK



S 08/11/10

Comment: DIMENSIONAL CHECK

12.0 POWDER COATING

POWDER COATING



(1x)

M 109152

Comment: POWDER COATING

1- Plug holes in D2581 prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

9'15  
OF

START TIME:

4:00

OVEN TEMPERATURE:

9'45

FINISH TIME:

10:00

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

10'30  
OF

START TIME:

4:00

OVEN TEMPERATURE:

11:00

FINISH TIME:

11:00

M 109152 08/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 42628C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/11/2008

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/2008 JF

Job Completion



MF 08-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

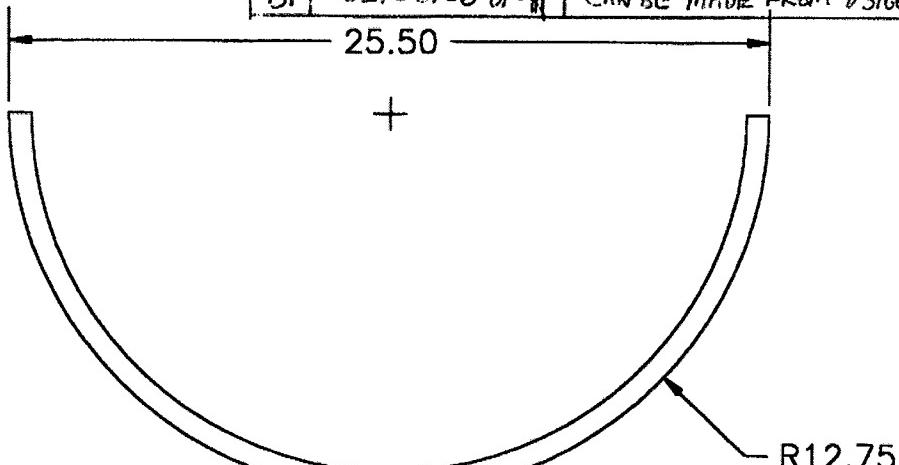
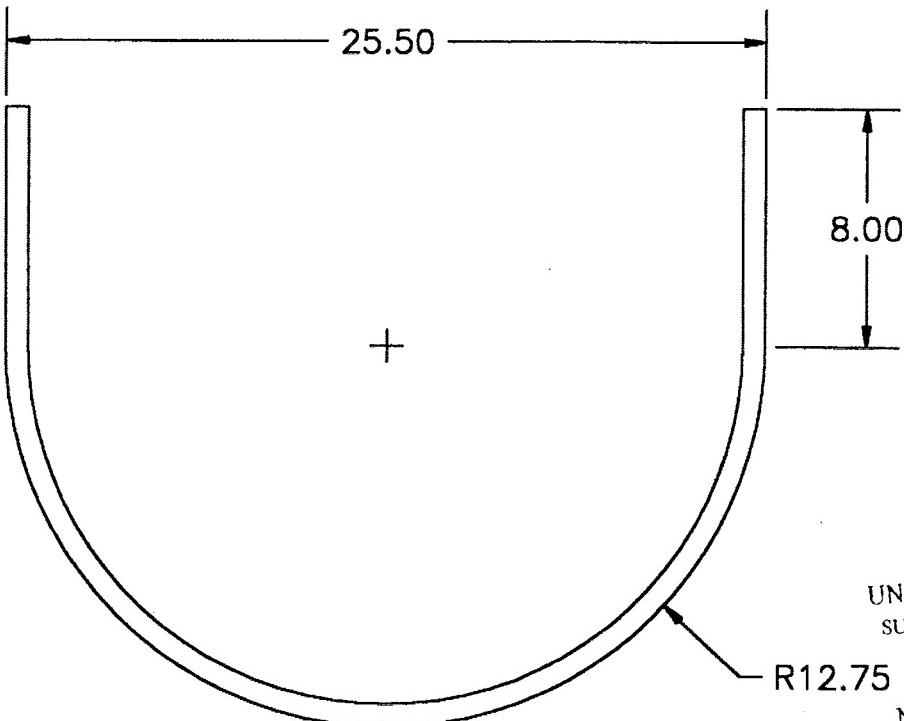
NOTE: Date & initial all entries

**DART**

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE

BI 02.08.06 ~~07~~ CAN BE MADE FROM D3166-1

RELEASED  
R 960507

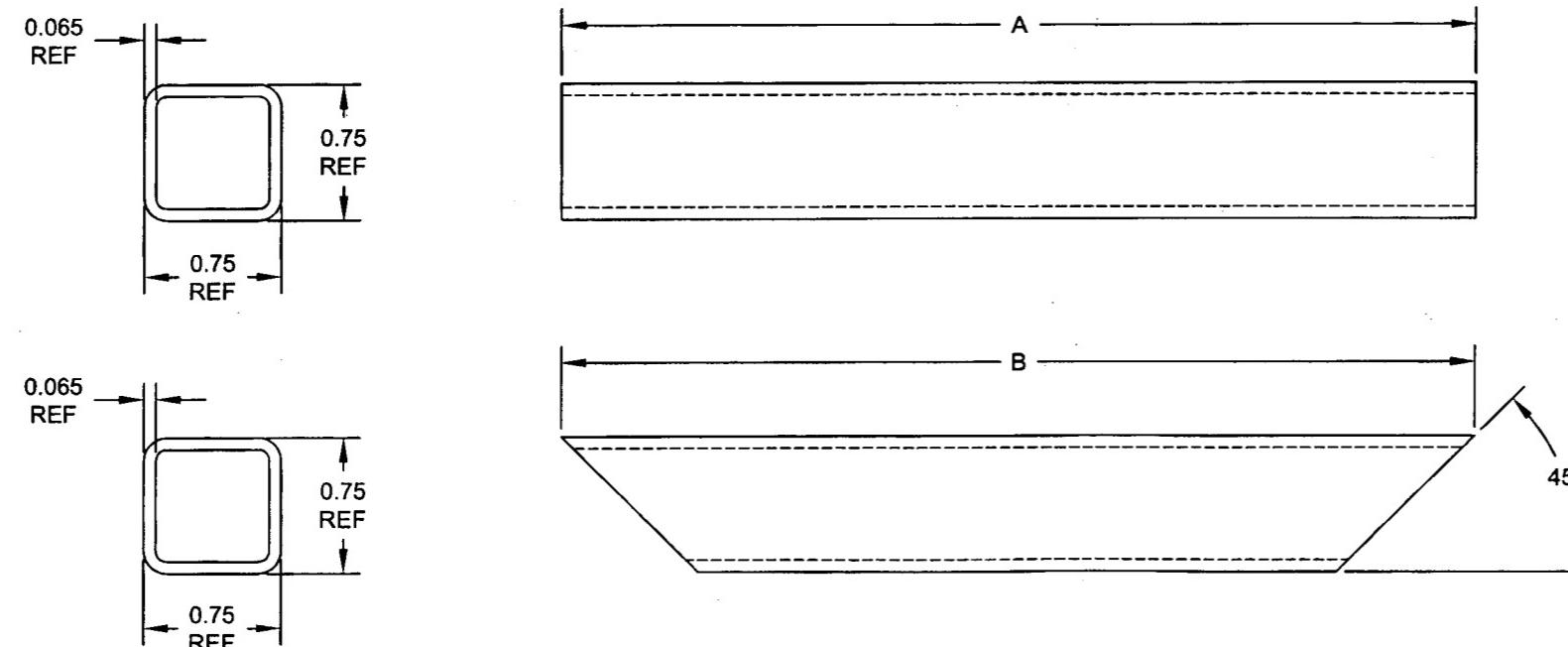
D2235-1D2235-3

CAN BE MADE FROM D3166-1 BI  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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WITHOUT NOTICE  
WORK ORDER  
NO. *420285*

## PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	SHIM



- D2221-1/-3/-5/-7  
 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST  
 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
 REF. DART SPEC M304TS0.750W.065  
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) ALL DIMENSIONS ARE IN INCHES

G

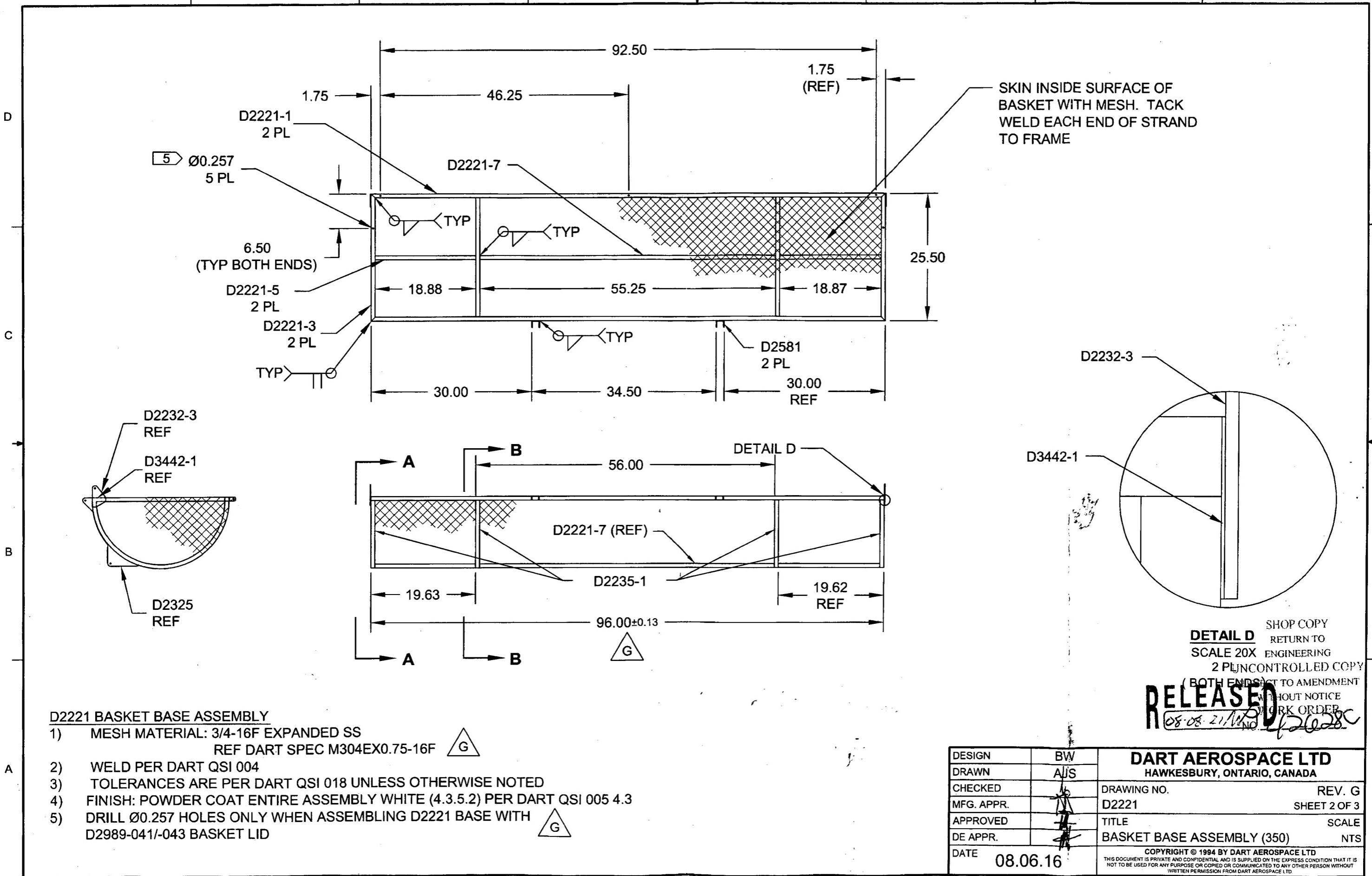
G	MATERIAL FCR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 2 ZN B,5 TOLERANCE FOR 96.00 DIM WAS +/- 0.01, 56.00 DIM WAS REF. SHT 2 ZN B4 19.62 DIM WAS "HARD" DIMENSION IS NOW REF.NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED. DRAWING TRANSFERRED TO "B" FORMAT.	AJS	08.06.16
F	ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPERATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. G	
APPROVED		D2221	
DE APPR.		SHEET 1 OF 3	
DATE	08.06.16	TITLE	
		SCALE	
		NTS	

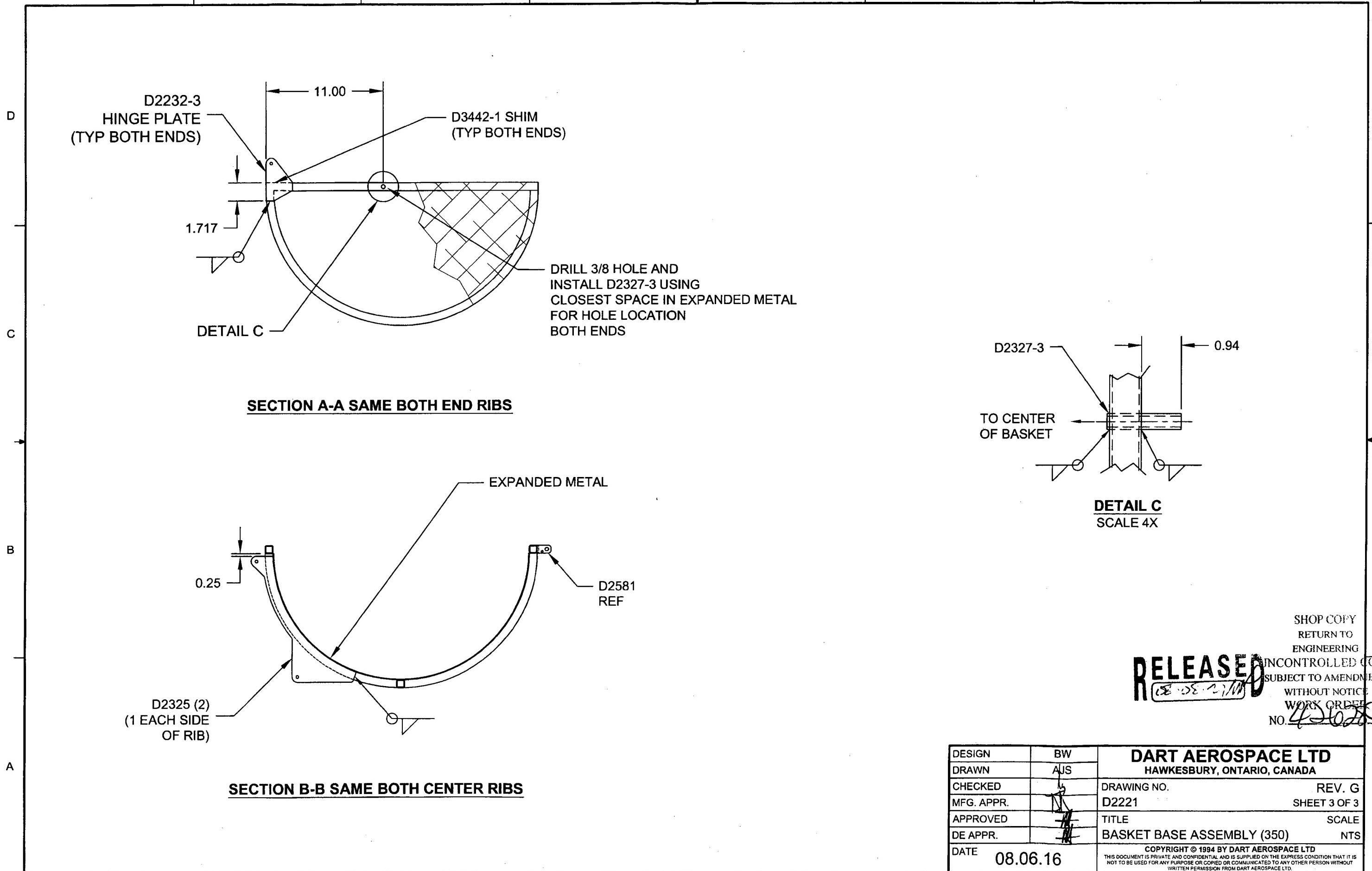
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 06-06-21/MH

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8 7 6 5 4 3 2 1



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